Work Order ID 6990	2
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Page 1

Tuesday, May 24, 2011 12:57:02 PM Item ID: D3536-23 Accept Setup Start **Revision ID:** Stop Item Name: Gasket **Start Qty: 16.00 Start Date:** 5/24/2011 **Cust Item ID:** Required Date: 5/31/2011 Req'd Qty: 16.00 **Customer:** Reference: Run Start Date: //-05-24 Tooling: Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Tool ID Reject Operation Set Up/ Tool # Plan Accept Reject Insp. Work Center ID **Description** Qty Qty Code Number Stamp **Run Hours** Draw Nbr **Revision Nbr** D3536 Rev A 100 0.00 FLOW WATER JET 1BI1-6-8 Waterjet 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D3536 □Dwg Rev: Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 B11-6-9 0.00 Memo Quality Control atruos 120 QC8- Inspect parts - second check

QC

Memo

0.00

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	ES			•
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
Resolution:			Dispositi	on:	_ QA: N/C Clo	Date: _		
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Sect		Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Work Order ID 69902

Tuesday, May 24, 2011 12:57:02 PM



Page 2

Item ID:

D3536-23

Accept



Setup Start

Stop



Revision ID:

Item Name:

Gasket

5/24/2011 **Start Date:** Required Date: 5/31/2011

Start Qty: 16.00

Req'd Qty: 16.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Start Run

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

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Picklist Print

Tuesday, May 24, 2011 12:57:10 PM

Work Order ID: 69902

Parent Item:

D3536-23

Parent Item Name: Gasket



Start Date: 5/24/2011

Required Date: 5/31/2011

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	189.1800	1.3365	23.76	26	40.	
											1811-6-	E)	

NEOPRENE SHEET 0.063

 Location
 Loc Qty
 Loc Code

 MAT052
 189.18

 117295
 189.18

11725



W/O:		WORK ORDER CHANGES										
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DART AEROSPACE LTD	Work Order:	69902
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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48.20	+/-0.030	49.20	>		7	
44.70	+/-0.030	44.70	*		Τ	
39.31	+/-0.030	39,31	*		7	
33.92	+/-0.030	33,92	_		7	
28.53	+/-0.030	28,53	8		lτ	
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Measured by:	ß	Audited by:		Prototype Approval:	N/A
Date:	11-6-8	Date:	alo6/08	Date:	N/A .

Rev	Date	Change	Revised,by	Approx/ed
Α	07.03.14	New Issue	KJ/JLM	

	-									
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DATE

06.10.25

GASKET

06.10.25

NEW ISSUE

CHECKED

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D3536-13 GASKET

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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- FINISH: NONE
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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2 OF 6 REV.

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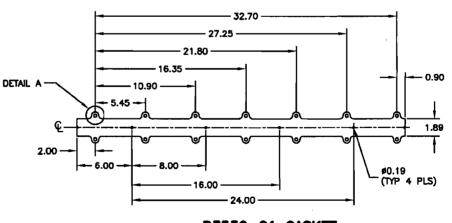
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D3536-15 GASKET

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- 2) FINISH: NONE
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- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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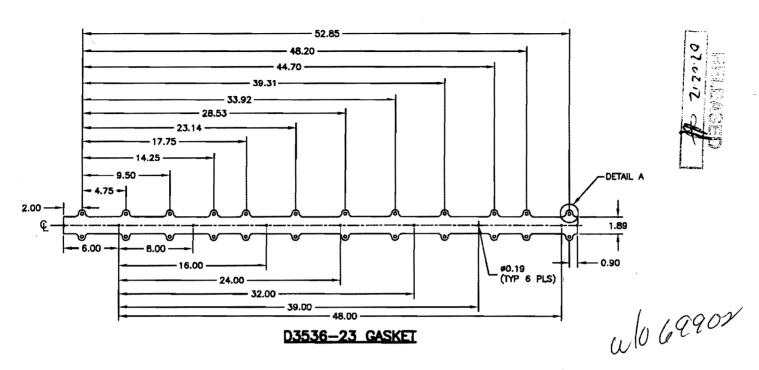
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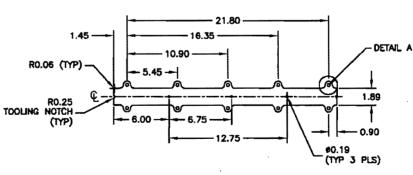
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4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
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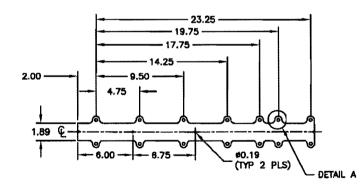
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D3536-35 GASKET

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

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D3536-31 GASKET

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- 2) FINISH: NONE

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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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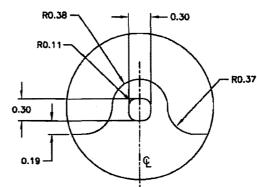
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D3536-41 GASKET

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
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